

Work Order ID 86872

86872

Page 1

July-06-12 3:19:24 PM

Item ID: D3417-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Washer
 Start Date: 7/06/12 Start Qty: 50.00 *50* Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 50.00 *50* Customer:
 Reference:

Approvals: Process Plan: Date: 12-07-10 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3417	Rev F								

100	Hardinge CNC LATHE SMALL	0.00							
100									
Doosan	Memo	0.00							
Doosan Lathe	1-Turn as per Folio FA761 Rev: <u> </u> & Dwg D3417 Rev: <u> </u> 2-Deburr		DAS 13 9-89	12/7/30					
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control			DAS 13 9-89	12/7/30					
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control			5mb 12-7-30	DAS 14 9-89 12/02/30					

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Item ID: D3417-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Washer

Start Date: 7/06/12 Start Qty: 50.00

50

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

(S/N) 12/7/30 SP

12/7/31 JJ
MCS 12107130

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Picklist Print

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Page 1

Work Order ID: 86872

Parent Item: D3417-5

Parent Item Name: Washer

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev: A New issue 08-07-09 JLM Verified By: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELNR1.2500 DELRIN ROUND BAR 1.25"		Purchased	No			110	f	7.4200	0.0296	1.557895			

Location

Loc Qty

Loc Code

MAT055

7.42

119133

0.92

121971

6.5

2R

2R DAS 13 12/7/30

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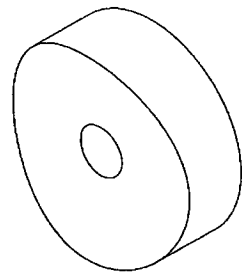
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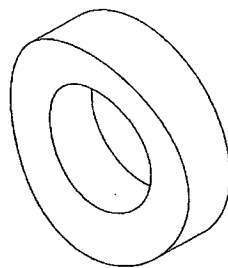
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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 86872

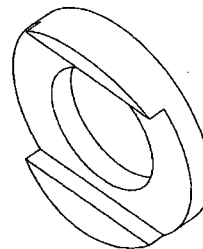
R1207-10



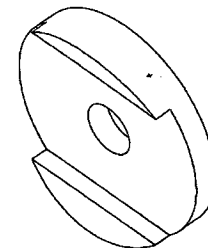
D3417-1 WASHER



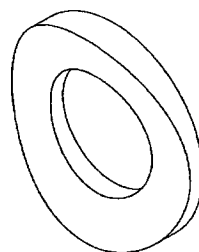
D3417-3 WASHER



D3417-5 WASHER



D3417-7 WASHER



D3417-9 WASHER

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2010-09-15
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NOTES:

- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD
REF DART SPEC M-DELRIN-R
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR
REF DART SPEC M-DELRIN-B
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET
REF DART SPEC M-DELRIN-S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3417-1, 0.020 lbs
D3417-3, 0.010 lbs
D3417-5, 0.010 lbs
D3417-7, 0.010 lbs
D3417-9, 0.004 lbs

F	ADD D3417-9 (ZN B5-3)	SC	10.07.26
E	ADD D3417-7 (ZN A2-2)	RF	09.06.30
D	ADD .5 WASHER (ZN B2-1, B2-2); REFORMAT TO 'B' SIZE & UPDATE TO CURRENT STANDARDS; REASON: INSTALLATION OF NEW TOW RING	AJS	08.07.08
C	REMOVE CBORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.06.10
A	NEW ISSUE	PH	05.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 1 OF 3
APPROVED		TITLE	SCALE
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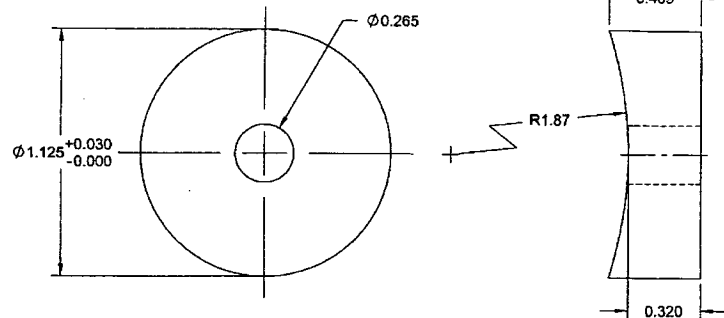
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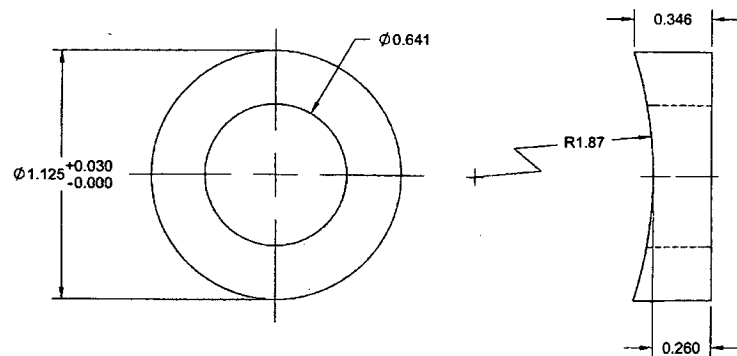
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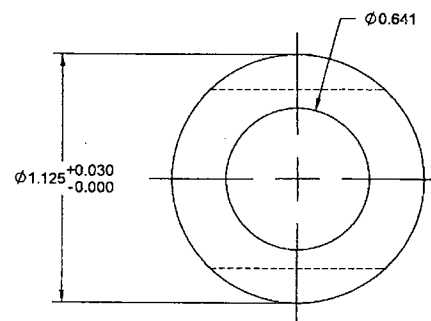
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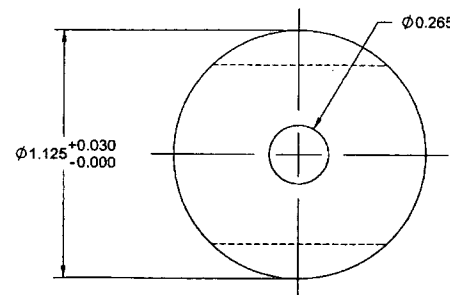
D3417-1 WASHER



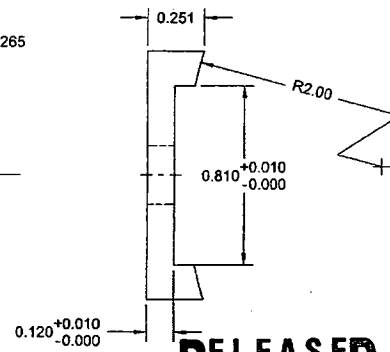
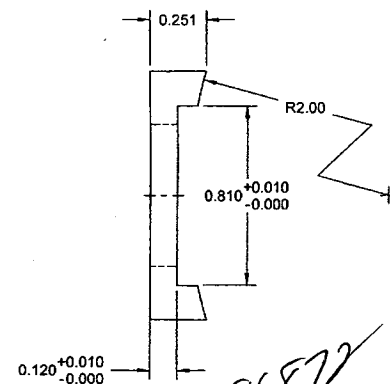
D3417-3 WASHER







D3417-5 WASHER



D3417-7 WASHER



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2010-09-15

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APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
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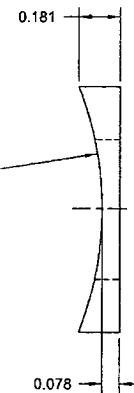
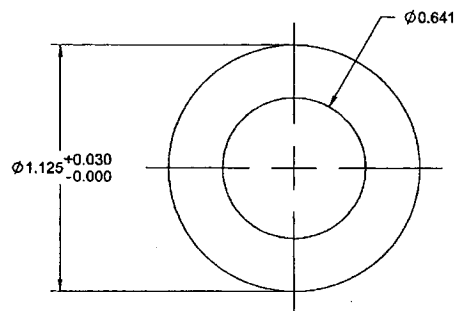
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D3417-9 WASHER

SLF72

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